

162909

Page 1

N900040100

Stop *NS2*

Stop *NS2*

4

4

Run Start *NR1*

Stop ***NR2***

SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

Work Order ID 162909***162909***

Page 2

Friday, June 16, 2017 8:16:07 AM

Item ID: D4149-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** Aft Crosstube Lug Assembly**Start Date:** 7/5/2017 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 7/7/2017 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.40

Quality Control

17/7/13
W 7.07.12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, June 16, 2017 8:16:05 AM

Page 1

Work Order ID: 162909

162909

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	685.0000	4	8		JUL 0 5 2017	
MS21043-3									**				
Nut													

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	119	
m136182	119	
GA	88	
m136182	88	
OVER007	300	
m137587	300	
ST302	98	
m137459	98	

DAS
6
9-89

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Friday, June 16, 2017 8:16:05 AM

Page 2

Work Order ID: 162909

162909

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

857.0000

1

12

MS21043-4

Nut

**

JUN 28 2017
DAS
6
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

99

m132803

5

m137371

94

OVER007

300

m137886

300

ST302

418

m137361

218

~~m137371~~

200

12

JUN 28 2017
JUL 05 2017

DAS
6
9-89

D3910-1

Manufactured

No

100

Each

20.0000

1

4

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

ST525

20

159145

20

4

JUL 05 2017
JUN 28 2017

DAS
6
9-89

D4091-1

Manufactured

No

100

Each

36.0000

1

4

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST525

36

161296

36

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Friday, June 16, 2017 8:16:05 AM

Page 3

Work Order ID: 162909

162909

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

D4149-1
D4149-1
Crosstube Lug Plate, Aft

Manufactured No

100 Each

4.0000

2 8

**

16290544

DAS
6
9-89

JUN 28 2017

Location

Loc Qty

Loc Code

ST086

4

161297

4

D4149-3
D4149-3
Spacer

Manufactured No

100 Each

13.0000

1 4

**

JUN 28 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST086

13

158877

13

D4149-5
D4149-5
Eyebolt Stud

Manufactured No

100 Each

21.0000

1 4

**

JUN 28 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST086

21

160618

20

160628

1

AN3C12A
AN3C12A
Bolt

Purchased No

100 Each

103.0000

2 8

**

JUN 28 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

28

M128727

7

M133990

21

ST349

75

M137507

75

Friday, June 16, 2017 8:16:05 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 4

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Parent Item: D4149-041

Parent Item Name: Aft Crosstube Lug Assembly

162909

D4149-041

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

AN4C13A

Purchased

No

100

Each

78.0000

3

12

AN4C13A

BOLT

**

DAS
9-89

JUL 05 2017

Location

Loc Qty

Loc Code

GA

26

m137699

26

ST344

52

m137321

2

m137495

50

MS20615-4M18

Purchased

No

100

Each

145.0000

3

12

MS20615-4M18

Rivet

**

DAS
9-89

JUL 05 2017

Location

Loc Qty

Loc Code

GA

40

m134762

40

ST306

105

m137361

100

m137459

5

NAS1149C0332R

Purchased

No

100

Each

3,160.000

4

16

NAS1149C0332R

WASHER

**

DAS
9-89

JUL 05 2017

Location

Loc Qty

Loc Code

FP001

1590

m137597

1590

GA

514

m133284

22

m136444

492

ST266

1056

m137381

1056

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																												
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																								
Root Cause		FAULT CATEGORY																																																														
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																															

Picklist Print

Friday, June 16, 2017 8:16:05 AM

Page 5

Work Order ID: 162909

162909

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

1,324.000

6

24

NAS1149C0432R

**

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

341

m134676

341

ST266

19

m136986

19

Sy266

964

m137459

964

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																